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D5134-041
Job Sheet 182317



Part No: D5134-041

Job Qty: 10 ea

Part Name: Damper Support Assembly, LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/22/18

Job Tracking No:

Due Date: 9/7/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IPP REV:A NEW ISSUE 14-09-09 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	9/7/18	9/7/18	0.00	0.00	Start Up Machining-3		SRL 18/09/08
100	Bandsaw	10 pcs	9/7/18	9/7/18	0.00	0.59	Bandsaw1		WAS 18/09/18
110	CNC Vertical Machining	10 pcs	9/7/18	9/7/18	1.03	23.26	HAAS1-4		WAS
120	QC	10 pcs	9/7/18	9/7/18	0.00	0.00	QC2 Machining-3		
130	QC	10 pcs	9/7/18	9/7/18	0.00	0.00	QC8 Machining-3		SP 18-09-19
135	HandFinish	10 pcs	9/7/18	9/7/18	0.00	0.66	HandFinish		DR 18/09/19
137	QC	10 pcs	9/7/18	9/7/18	0.00	0.00	QC7-4		AS SEP 20 2018
140	SprayPaint	10 pcs	9/7/18	9/7/18	0.00	2.60	Spray Paint		AS SEP 20 2018
150	QC	10 pcs	9/7/18	9/7/18	0.00	0.00	QC14		SEP 24 2018
160	Small Fab	10 pcs	9/7/18	9/7/18	0.00	1.44	Small Fab-8		SM 13 9-8-18
170	QC	10 pcs	9/7/18	9/7/18	0.00	0.00	QC5		38
180	Packaging	10 pcs	9/7/18	9/7/18	0.00	0.00	Packaging3-2	LG054	AS 9-8-18
190	QC21-SA	10 Ea	9/7/18	9/7/18	0.00	0.00	QC21		ML 18-09-24

Part Op 100 - CUT BLANK TO 5.125" LONG *****CHECK GRAIN DIRECTION*****

Descriptions: 110 - Mill as per Dwg and folio FB342

140 - ***MASK BEARING HOLE AS PER NOTE 2*** PRIME AS PER DWG AND C. BATCH: 138877 PAINT AS

PER DWG AND QSI BATCH: 138949

160 - install bushings as per dwg

180 - LOCATION : LG054

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T73B3.000X4.000	7075-T73 Bar 3.0 X 4.0 Grain Direction Along 3"	4.2700 ft (.427 ea)	90-Start up Operation	5108279
NAS77C6-021	Bushing	20 Ea (2 ea)	160-Small Fab	fm134793 fm134833

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M7075T73B3.000X4.000	4	21	0
160-Small Fab	NAS77C6-021	20	251	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
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1	Damper Support Assembly, LH	0.360Inches $\pm$ 0.030	0.390 0.330	0.3565
2	Damper Support Assembly, LH	0.188Inches + 0.005 - 0.001	0.193 0.187	0.188
3	Damper Support Assembly, LH	0.257Inches + 0.006 - 0.001	0.263 0.256	0.257
4	Damper Support Assembly, LH	1.932Inches $\pm$ 0.010	1.942 1.922	1.932
5	Damper Support Assembly, LH	0.632Inches $\pm$ 0.010	0.642 0.622	0.642
6	Damper Support Assembly, LH	0.632Inches $\pm$ 0.010	0.642 0.622	0.642
7	Damper Support Assembly, LH	0.730Inches $\pm$ 0.010	0.740 0.720	0.730
8	Damper Support Assembly, LH	0.500Inches + 0.000 - 0.010	0.500 0.490	0.4995
9	Damper Support Assembly, LH	0.100Inches $\pm$ 0.010	0.110 0.090	0.103
10	Damper Support Assembly, LH	0.728Inches $\pm$ 0.010	0.738 0.718	0.728
11	Damper Support Assembly, LH	0.250Inches $\pm$ 0.030	0.280 0.220	Radius ✓
12	Damper Support Assembly, LH	0.630Inches $\pm$ 0.030	0.660 0.600	Radius ✓
13	Damper Support Assembly, LH	0.063Inches $\pm$ 0.010	0.073 0.053	Radius ✓
14	Damper Support Assembly, LH	0.117Inches $\pm$ 0.010	0.127 0.107	0.120
15	Damper Support Assembly, LH	0.177Inches $\pm$ 0.010	0.187 0.167	0.185
16	Damper Support Assembly, LH	0.841Inches $\pm$ 0.010	0.851 0.831	0.841
17	Damper Support Assembly, LH	0.208Inches $\pm$ 0.010	0.218 0.198	0.209
18	Damper Support Assembly, LH	0.208Inches $\pm$ 0.010	0.218 0.198	0.209
19	Damper Support Assembly, LH	0.860Inches $\pm$ 0.010	0.870 0.850	0.858
20	Damper Support Assembly, LH	1.471Inches $\pm$ 0.010	1.481 1.461	1.471
21	Damper Support Assembly, LH	0.130Inches $\pm$ 0.030	0.160 0.100	Radius ✓

Plex 8/22/18 12:58 PM Dart.lajeunesse.marie

MD
11 Jul 2019



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

NCR No.

19-7298

Job:

182313

Part No.

DS34041

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☒

DEPARTMENT/PROCESS

Cross tube ☐
Small Fab ☐
Finishing ☐
Skid-tube ☐
Machining ☒
Large Fab ☐
Eng. (Non-AW) ☐
Prod. Eng. Coord. ☐
Rec/Store/Packaging ☐
Engineering ☐
Water Jet ☐
Supplier ☐
Quality ☐

Date:

18/9/17

Sequence #:

Description Work Order Deviation

Dm 0.841 is under tolerance, up to 0.627.

QTY Affected:

Disposition

Acceptable. No effect on strength or function of the damper. Check-fit with OEM showed no effect on fit.

MRB (QSI042)

DAS 12 18/9/17
9-89

Completed By

DAS 12 18/9/17
9-89

Lead hand / Supervisor

D.E 18-09-19

QC / QA Coordinator

DAS 55 9-89

19-7-11

Root Cause

Operator ☒
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Preservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

Pressure/Forced Bending ☐
Crushing ☐
Cracks ☐
Crimp/Kink/Ripple/Wave/Twist ☐
Marks/Chatter ☐
Mislabeled ☐
Contamination ☐
Misaligned/off center ☐
BOM/Route ☐
Broken/Damage/Defect ☐
Incomplete/Unclear Instructions ☐
Drill Holes ☐
Fit/Function ☐
Power Loss/Surge ☐
Folio/Program ☐
Grain Direction ☐
Weld ☐
Wrong Stock Pulled ☐
Out of Sequence ☐
Off-set/Set-up ☐

Positioned Wrong ☐
Outside Tolerance ☒
Drawing ☐
Finish ☐
Part Lost/Missing ☐
Misread ☐

Other/Details: